

Work Order ID 70934

Monday, June 20, 2011 8:24:04 AM



Page 1

Item ID: D206-642-312BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10620

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| IIN-D206-642 | N |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

8/10/08/09

CRK Rel 8/6/11/09/09

110

0.00



Pick Kit

Memo

0.00

Packaging

Packaging

11/7/26-28

120

0.00



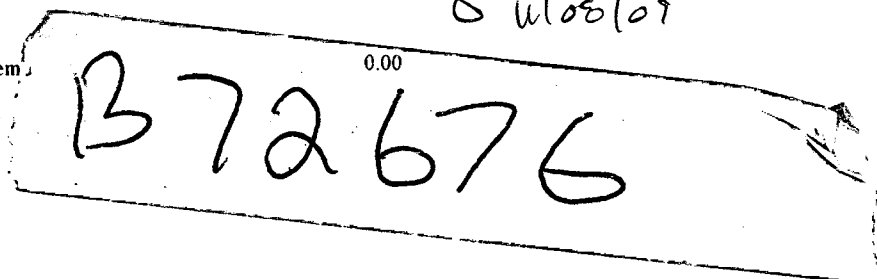
QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

8/10/08/09



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 70934

Monday, June 20, 2011 8:24:05 AM

Page 2

Item ID: D206-642-312BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube RH

Start Date: 6/20/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: _____ | | | | | | | | |
| 140  | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

ck 11/08/09

MF 11-08-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:24:13 AM

Page 1

Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH



Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev: M
 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D206-642-341

Manufactured

No

110

Each

3.0000

1



Replacement Skidtube



B72676 sf

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

CHG002

Manufactured

No

110

Each

8.0000

1



GHW Modification



B72402 sf

Location

Loc Qty

Loc Code

FG120

8

68347

4

69933

2

70889

2

ATTN: D3414-041 BLUE

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2932-2

Manufactured No

110

Each

6.0000



Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

3

67253

3

ST428

3

69027

3



~~B71057~~
67253

BLUE

D2933-2

Manufactured No

110

Each

4.0000



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

2

67254

2

ST428

2

69029

2



B71063 11/2/2011

BLUE

D2938-2

Manufactured No

110

Each

3.0000



Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

2

67255

2

ST428A

1

69036

1



B71059 11/2/2011

BLUE

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2939-2

Manufactured No

110

Each

4.0000



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

2

67256

2

ST428A

2

69031

2

BLUE

AN3-41A

Purchased

No

110

Each

251.0000



Bolt

Location

Loc Qty

Loc Code

ST354

251

112431

1

116191

200

117794

50

D2652

Manufactured

No

110

Each

328.0000



Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

284

68102

200

68941

84

Monday, June 20, 2011 8:24:14 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:24:14 AM

Page 4

Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,107.000

8

8



Nut

Location

Loc Qty

Loc Code

ST300

2107

116391

9

116549

398

117441

800

117601

400

117885

500

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

8



Washer

AN5-10A

Purchased

No

110

Each

308.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST337

308

117313

83

117795

125

117872

100

AN5-11A

Purchased

No

110

Each

62.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST337

62

117313

62

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

8

8



Washer

Monday, June 20, 2011 8:24:14 AM

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Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:24:14 AM

Page 5

Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-6A
Bolt

Purchased No

110 Each

1,200.000 12 12

Location

Loc Qty

Loc Code

ST356

1000

116400

400

116924

400

117872

200

ST358

200

117514

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000 24 24

Washer

MS21042L4

Purchased

No

110

Each

4,974.000 12 12

Nut

Location

Loc Qty

Loc Code

ST300

4974

117441

2680

117601

794

117885

1500

D3407-043

Manufactured

No

110

Each

14.0000 1 1

Tow Ring

Location

Loc Qty

Loc Code

ST464

14

68339

2

69540

12

BLUE

Monday, June 20, 2011 8:24:15 AM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:24:15 AM

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Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

48.0000

1

1



Washer



B710338

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

41

66848

3

69774

38

D3457-1

Manufactured No

110

Each

18.0000

2

2



Washer



B76774

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

8

67779

8

MS21043-4

Purchased No

110

Each

1,111.0000

1

1



Nut



11/8/27

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

71

117423

71

ST301

1000

117601

500

117793

500

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:24:15 AM

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Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C5A Purchased No

110 Each

517.0000



BOLT

Location

Loc Qty

Loc Code

FP-B

110

112243

110

ST345

407

112243

407

AN960C416 NAS1149C0463 Purchased No

110 Each

0.0000



washer

D3413-1

Manufactured No

110 Each

21.0000



Ring

Location

Loc Qty

Loc Code

ST420

15

62961

8

66387

7

ST473

6

66945

6

BLUE D2712 Manufactured No

110 Each

301.0000



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

251

66955

251

Monday, June 20, 2011 8:24:15 AM

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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Monday, June 20, 2011 8:24:15 AM

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Work Order ID: 70934

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH



Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2934

Manufactured No

110

Each

44.0000

2 2



Saddle Spacer



B70772

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

38

67585

10

69745

28

D2935

Manufactured No

110

Each

34.0000

2 2



Saddle Spacer



B70770 11/7/2011

Location

Loc Qty

Loc Code

ST027

34

66564

34

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

| Item | Qty -311 | Qty -312 | Qty -341 | Qty -347 | Qty -013 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|----------------------|---|
| | X | | | | | D206-642-311 | SKIDTUBE INSTALLATION, LH |
| | | X | | | | D206-642-312 | SKIDTUBE INSTALLATION, RH |
| | 1 | 1 | X | | | D206-642-341 | SKIDTUBE |
| | | | | X | | D206-642-347 | WEARSHOE KIT (REPLACES -343) |
| | 1 | 1 | | | X | D206-648-013 | GROUND HANDLING KIT |
| 1 | | | 1 | | | D2650-5 | SKIDTUBE ASSEMBLY |
| 2A | | | 14 | | | D2651-1 | * PLUG ⁽¹⁾ |
| 2B | | | 14 | | | D2651-3 | * O-RING ⁽¹⁾ |
| 3 | | | 1 | | | D2646 | * AFT CAP ⁽¹⁾ |
| 4 | | | 2 | | | MS27039-1-08 | * SCREW ⁽¹⁾ |
| 5 | | | 2 | | | AN960JD10L | * WASHER ⁽¹⁾ |
| 6 | 1 | | | | | D2932-1 | SADDLE, FWD OUT, LH |
| 6 | | 1 | | | | D2932-2 | SADDLE, FWD OUT, RH |
| 7 | 1 | | | | | D2933-1 | SADDLE, FWD IN, LH |
| 7 | | 1 | | | | D2933-2 | SADDLE, FWD IN, RH |
| 8 | 1 | | | | | D2938-1 | SADDLE, AFT OUT, LH |
| 8 | | 1 | | | | D2938-2 | SADDLE, AFT OUT, RH |
| 9 | 1 | | | | | D2939-1 | SADDLE, AFT IN, LH |
| 9 | | 1 | | | | D2939-2 | SADDLE, AFT IN, RH |
| 10 | 8 | 8 | | | | AN3-41A | BOLT |
| 11 | 16 | 16 | | | | D2652 | BUSHING |
| 12A | 8 | 8 | | | | MS21042-3 | NUT (OR MS21042L3) |
| 12B | 8 | 8 | | | | AN960JD10 | WASHER |
| 13 | 4 | 4 | | | | AN5-10A (OR AN5-11A) | * BOLT ⁽²⁾ |
| 14 | 4 | 4 | | | | AN5-11A (OR AN5-12A) | * BOLT ⁽²⁾ |
| 15 | 8 | 8 | | | | AN960JD516 | WASHER |
| 16 | 12 | 12 | | | | AN4-6A | BOLT |
| 17 | 24 | 24 | | | | AN960JD416 | WASHER |
| 18 | 12 | 12 | | | | MS21042-4 | NUT (OR MS21042L4) |
| 20A | | | 6 | 6 | | D3537-1 | WEARPAD (REPLACES D2648-3) |
| 21A | | | 1 | 1 | | D3537-3 | WEARPAD (REPLACES D3429-1) |
| 22A | | | 1 | 1 | | D3535-11 | WEARSHOE (REPLACES D2656-11) |
| 22B | | | 1 | 1 | | D3536-11 | GASKET |
| 23A | | | 1 | 1 | | D3535-23 | WEARSHOE (REPLACES D2656-23) |
| 23B | | | 1 | 1 | | D3536-23 | GASKET |
| 24A | | | 1 | 1 | | D3535-35 | WEARSHOE (REPLACES D2656-35) |
| 24B | | | 1 | 1 | | D3536-35 | GASKET |
| 26A | | | 54 | 54 | | MS27039C1-08 | SCREW |
| 26B | | | 54 | 54 | | AN960C10L | WASHER |
| 26C | | | 54 | | | ALS7-1032-130 | * INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 30 | 1 | 1 | | | | D3407-043 | TOW RING ASSEMBLY (REPLACES D2968-043) |
| 31 | 1 | 1 | | | | D3456-1 | WASHER |
| 32 | 1 | 1 | | | | D3457-1 | WASHER |
| 33 | 1 | 1 | | | | MS21043-4 | NUT |
| 34 | 1 | 1 | | | | AN4C5A | BOLT |
| 35 | 1 | 1 | | | | AN960C416 | WASHER |
| 36 | 1 | 1 | | | | D3413-1 | RING (REPLACES D2655) |
| 37 | 10 | 10 | | | | D2712 | SET SCREW |
| 38 | 2 | 2 | | | | D2934 | SADDLE SPACER |
| 39 | 2 | 2 | | | | D2935 | SADDLE SPACER |
| 40 | | | | | 2 | D3414-041 | GHW LUG (REPLACES D2659) |
| 41 | | | | | 4 | AN3C37A | BOLT |
| 42 | | | | | 8 | D2652 | BUSHING |
| 43 | | | | | 4 | MS21043-3 | NUT |
| 44 | | | | | 4 | AN960C10 | WASHER |

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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